

Date: Monday, 2/4/2008 11:28:03 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL LOCK BASE
Job Number : 37186	
Estimate Number : 11345	
P.O. Number :	Part Number : D33701
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D3370 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By : <u>JA 08 02 04</u>	Due Date : 2/15/2008 Qty: 8 Um: Each
Checked & Approved By : <u>JA 08 02 04</u>	
Comment : Est. B 05.05.25 Added Powder Coat K/J/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"
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Comment: Qty.: 0.3657 f(s)/Unit Total: 2.9257 f(s) M 10974 08/02/07 (8)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368
Identify as D3368-1
Deburr ml 08/02/07 (8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 08/02/11 (12)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK ml 08/02/13 (13)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 BL 08-02-13 (13)

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 M 18052 08/02/13 (13X)

66 QC3

ML 08-02-15 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 08/02/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:28:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 37186

Part Number: D33701

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST492

AS 08/02/19

(13)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(13)

Comment: FINAL INSPECTION/W/O RELEASE

AS 08/02/19

Job Completion



U 08.02.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37186
Description: Pedal Lock Base		Part Number:	D3370-1
Inspection Dwg: D3370 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

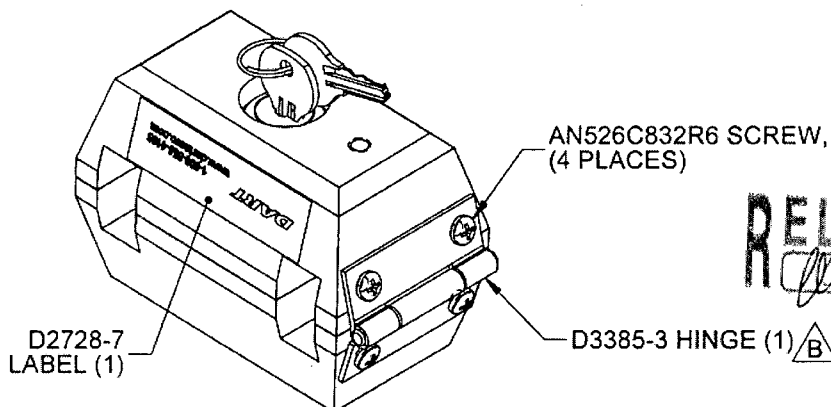
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	/			
0.202	+/-0.010	.210	/			
0.592	+/-0.010	.594	/			
0.550	+/-0.010	.554	/			
0.760	+/-0.010	.759	/			
1.50	+/-0.030	1.501	/			
1.188	+/-0.010	1.183	/			
1.232	+/-0.010	1.223	/			
R0.500	+/-0.010	R.500	/			
2.35	+/-0.030	2.346	/			
1.920	+/-0.010	1.917	/			
0.450	+/-0.010	.4475	/			
1.673	+/-0.010	1.669	/			
2.638	+/-0.010	2.634	/			
4.00	+/-0.030	4.001	/			
Ø0.203	+0.005/-0.000	Ø.205	/			
0.250	+/-0.030	.250	/			
1.450	+/-0.005	1.450	/			
0.450	+/-0.010	.450	/			
15°	+/-0.1°	15°	/			

Measured by:	SA	Audited by:	gml	Prototype Approval:	N/A
Date:	08/02/11	Date:	08/02/13	Date:	N/A

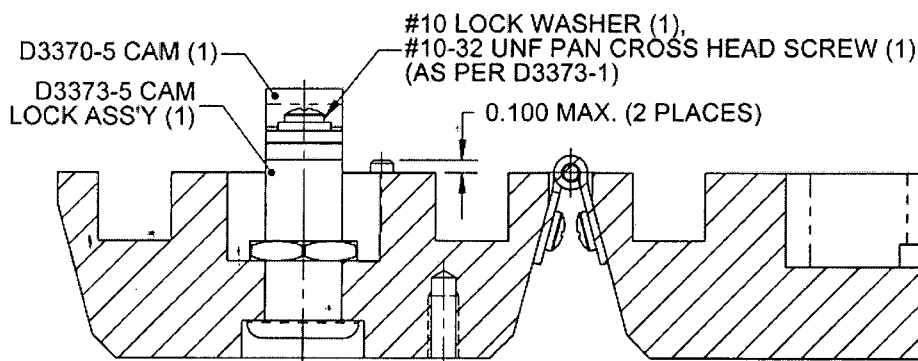
Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	



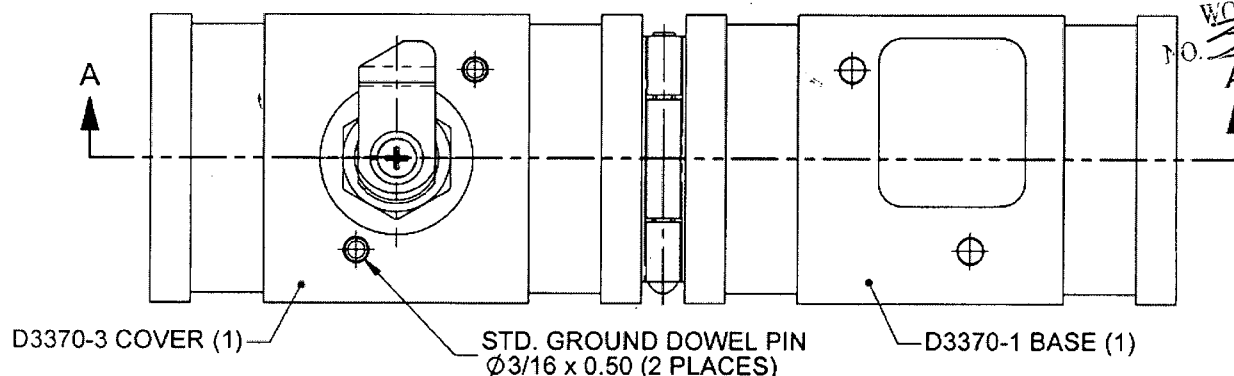
DESIGN 5	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED	DRAWING NO. D3370	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:1.5
A	04.12.15	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3370-051 PEDAL LOCK ASSEMBLY

NOTES:

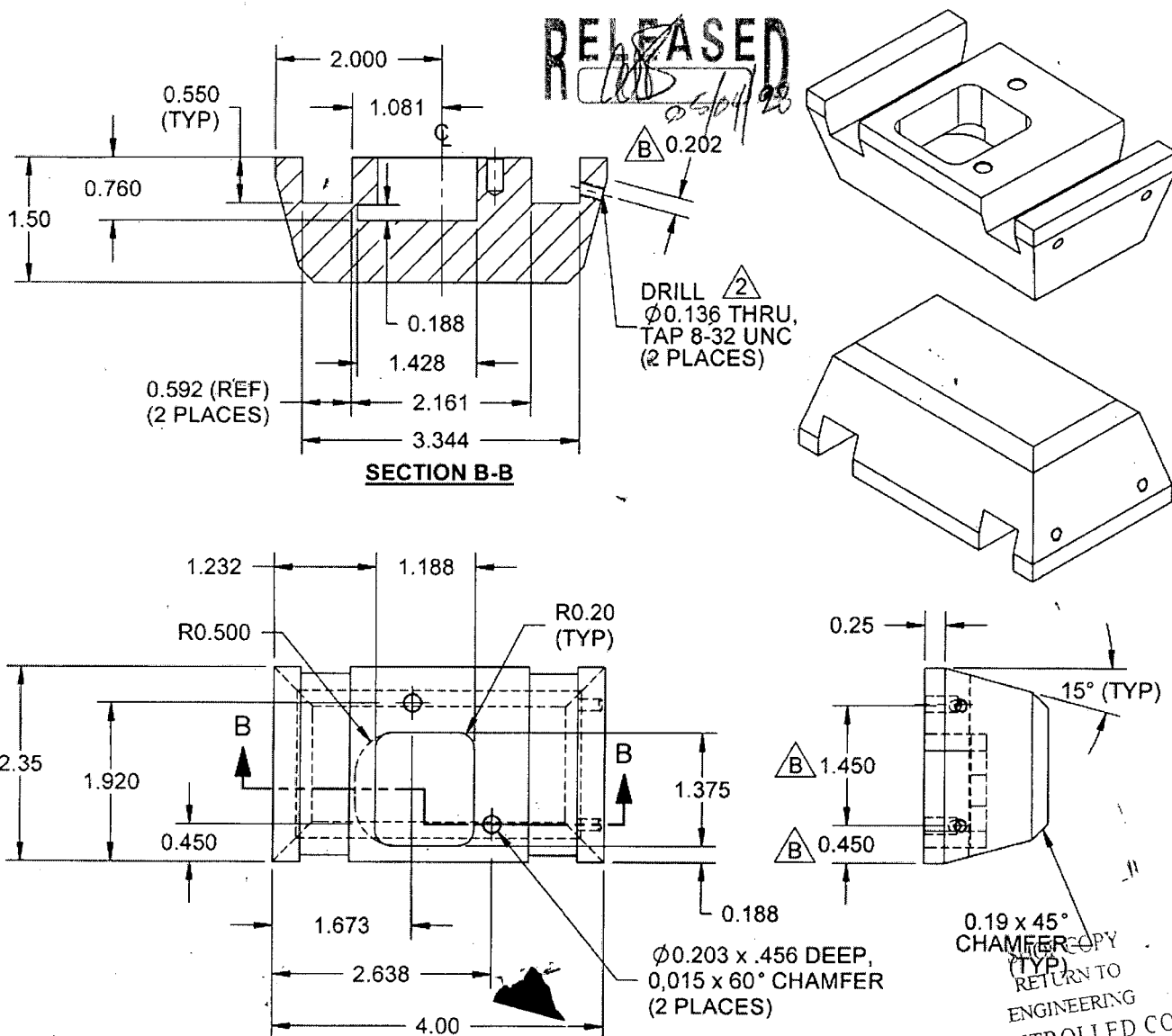
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



D3370-1 BASE

NOTES:

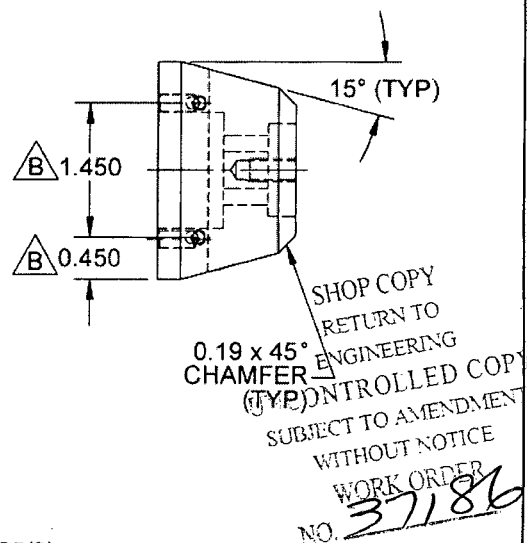
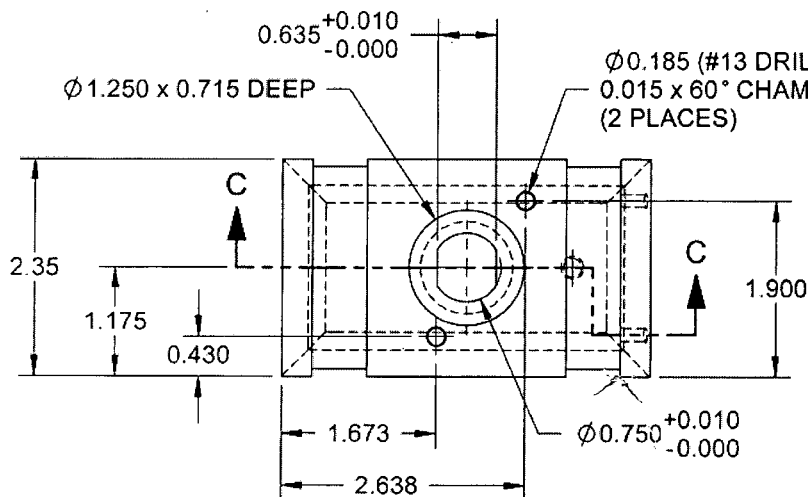
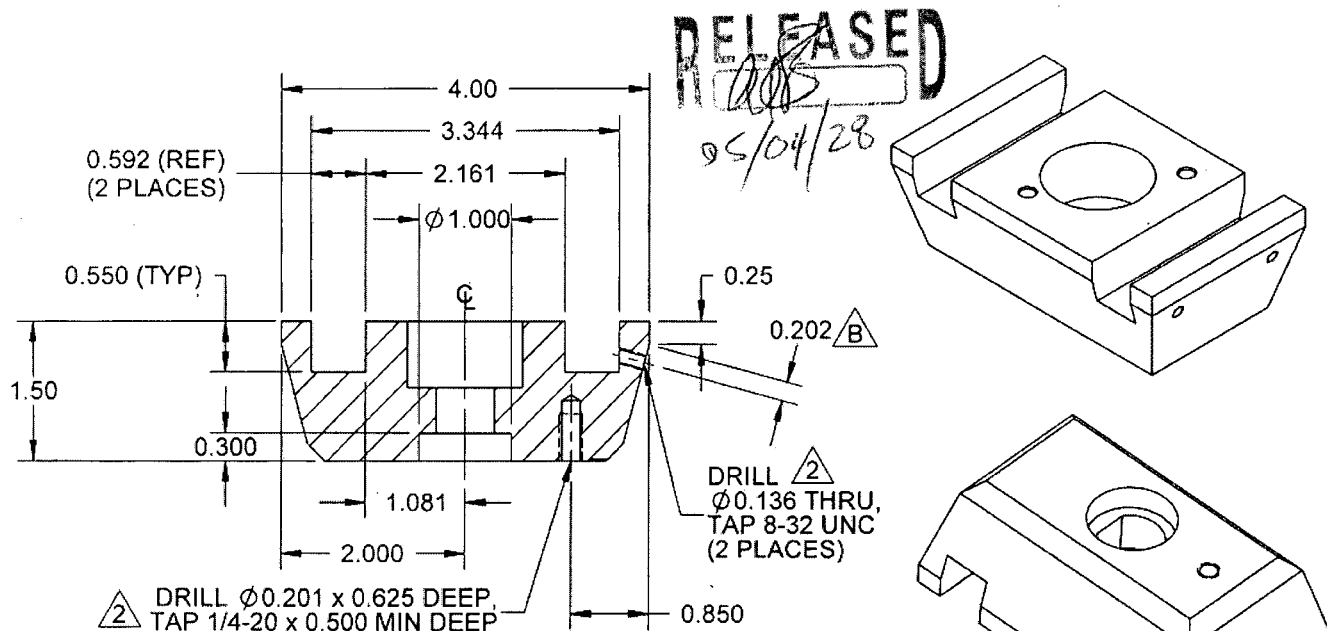
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2



NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

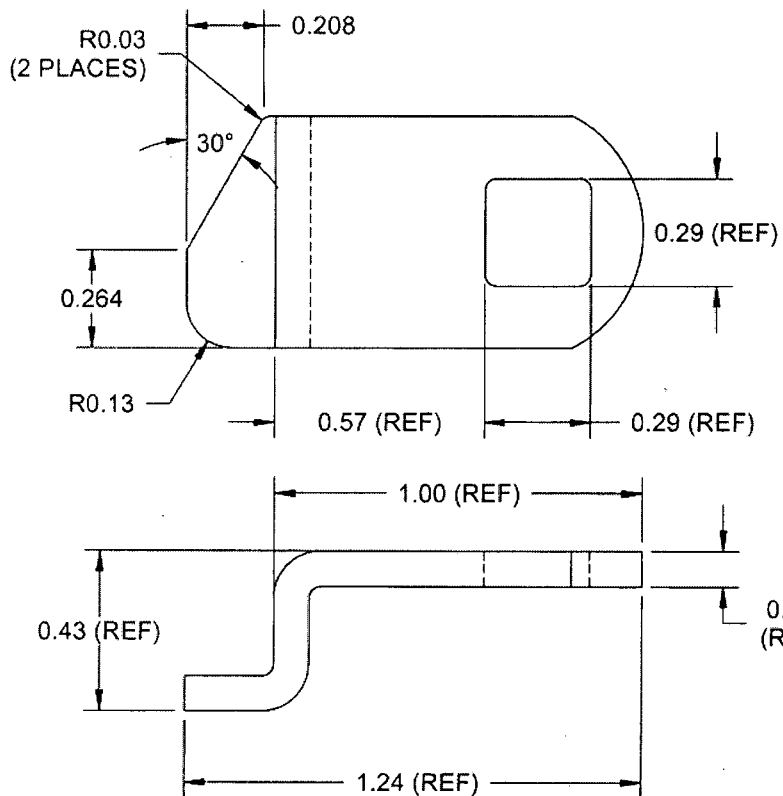
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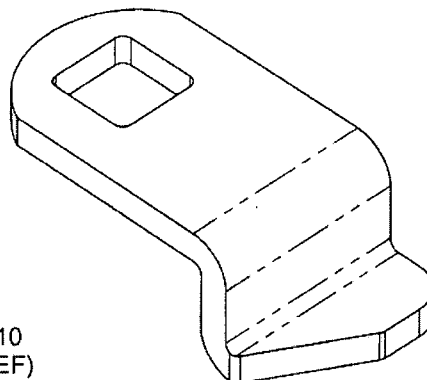


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3370	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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05/04/28



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WITHOUT NOTICE
WORK ORDER
NO. **37186**

D3370-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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